

Work Order ID 61811

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Tuesday, September 07, 2010 12:41:08 PM

Item ID: D4102-1

Accept



Setup Start



Revision ID:

Item Name: SHIM

Stop



Start Date: 9/7/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 10/13/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/09/07

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4102	B

100 Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

4.950" long

110



HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

MILL AS PER DWG AND FOLIO FA945

FOLIO REV: B

DWG REV: B

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4102-1 PAR #: Fault Category: MACHINING NCR: Yes No DQA: Date: 10/10/07
 Resolution: (1) SCRAP / (2) Accepted Disposition: (1) SCRAP / (2) USE AS IS QA: N/C Closed: Date: 10/07/2010

NCR: 61811		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
(1) 10/09/27	110	- machined part is the wrong version of pattern. - engineering has not notify about changes before w/o was released	10/09/27	- program has been updated	8. A 10/09/27	OK 10/09/30	10/09/27	10/09/28
		- program was not updated.	10/09/27	- Attempt to re-machine the pocket per drawing, to save the part. NOT machinable	N/A. 10/09/27	Parts could not be re-machined due to contour change 10/09/25	10/09/27	10/09/28
(2) 10/09/28	110	Two parts are affected by one dimension under Tolerance .130" +.000-.015. Actual dimension .113" R.C. Process.	10.09.28 10/09/28	No replace. No more material. Acceptable.	8.8 10/09/28	OK 10/09/30	10.09.28 10/09/28	10/09/28

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

M. A 10/09/27

12

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

amk 10/09/30

12

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

M 10/10/00

12

0

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 61811

Tuesday, September 07, 2010 12:41:08 PM



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Item ID: D4102-1

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Setup

Start



Revision ID:

Item Name: SHIM

Stop



Start Date: 9/7/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 10/13/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

DR 10-10-1

160



Packaging

Packaging

Identify as per dwg & Stock Location

125

0.00

12 φ

10/10/4 sl 10/10/4

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/104 D

ME

10-10-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, September 07, 2010 12:41:12 PM

Work Order ID: 61811



Parent Item: D4102-1



Parent Item Name: SHIM

Start Date: 9/7/2010

Required Date: 10/13/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-07-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X04.00 0		Purchased		No		100	f	15.8670	0.042	0.442105			

6061-T6 Bar .250 x 4.00



Location	Loc Qty	Loc Code
MAT	15.866978	
114608	15.866978	

5.197 on 10/09/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 61811
Description: SHIM	Part Number: D4102-1
Inspection Dwg: D4102 Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	ACTUAL Dimensions	MANUFACTURER TOLERANCES	Accept	Reject	Method of Inspection	Comments
0.426	0.429	+/- .010	✓		Veru	GA-01
0.495	0.498	+/- .010	✓		✓	✓
0.630	0.633	+/- .010	—		✓	✓
0.675	0.678	+/- .010	✓		✓	✓
1.10	1.103	+/- .030	—		✓	✓
1.413	1.416	+/- .010	~		✓	✓
2.656	2.659	+/- .010	—		✓	✓
2.90	2.903	+/- .030	✓		✓	✓
3.035	3.038	+/- .010	✓		✓	✓
3.510	3.513	+/- .010	~		✓	✓
3.644	3.647	+/- .010	—		✓	✓
4.00	4.012	+/- .030	✓		✓	✓
6.00	6.00	+/- .010	~		✓	✓
0.718	0.718	+/- .010	✓		✓	✓
1.125	1.125	+/- .010	~		✓	✓
1.534	1.534	+/- .010	—		✓	✓
2.290	2.290	+/- .010	✓		✓	✓
2.315	2.315	+/- .010	~		✓	✓
3.418	3.418	+/- .010	✓		✓	✓
3.370	3.370	+/- .010	—		✓	✓
3.770	3.770	+/- .010	✓		✓	✓
3.940	3.940	+/- .010	~		✓	✓
4.234	4.234	+/- .010	✓		✓	✓

Measured by: J.A	Audited by: <i>mk</i>	Preliminary Approval:
Date: 10/09/27	Date: 10/09/30	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD	Work Order:	61811
Description: SHIM	Part Number:	D4102-1
Inspection Dwg: D4102 Rev: B		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<u>H. A</u>	Audited by:	<u>Graf</u>	Preliminary Approval:	
Date:	<u>10/09/27</u>	Date:	<u>10/09/30</u>		Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

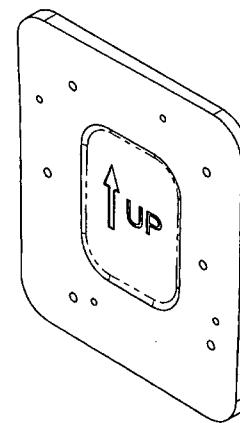
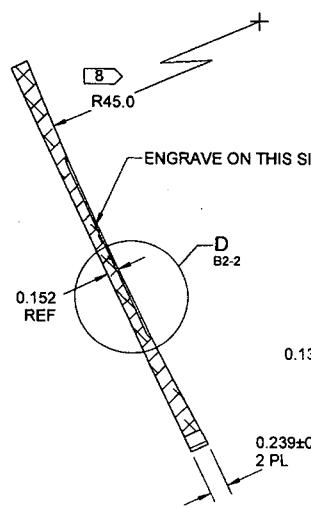
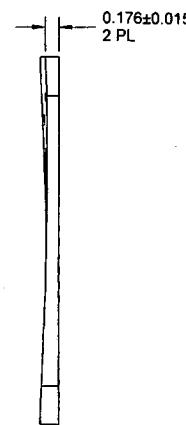
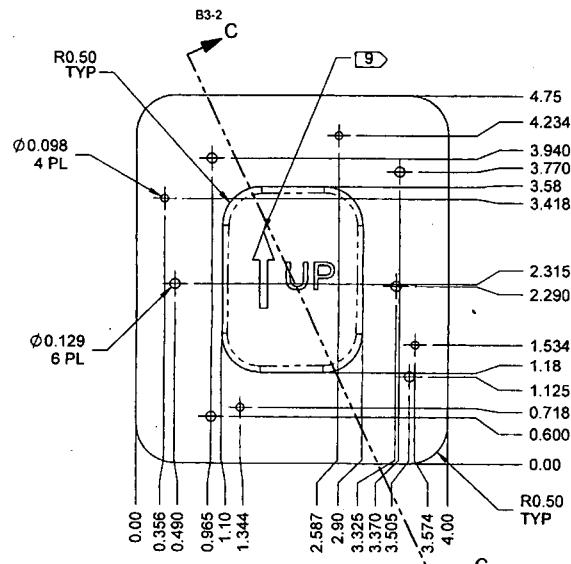
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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W0 G18/1
D4102-2 SHIM B

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
PER DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4102-2" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.30 lbs
- 8) SURFACE FINISH MINIMUM 250 MICROINCH
- 9) ENGRAVE "UP & ARROW" TO A DEPTH OF MAXIMUM 0.020 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.063

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. B	
MFG. APPR.		D4102	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SHIM	NTS
DATE	10.08.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	

RELEASED
2010-08-23
W

8 7 6 5 4 3 2 1

D

C

B

A

1

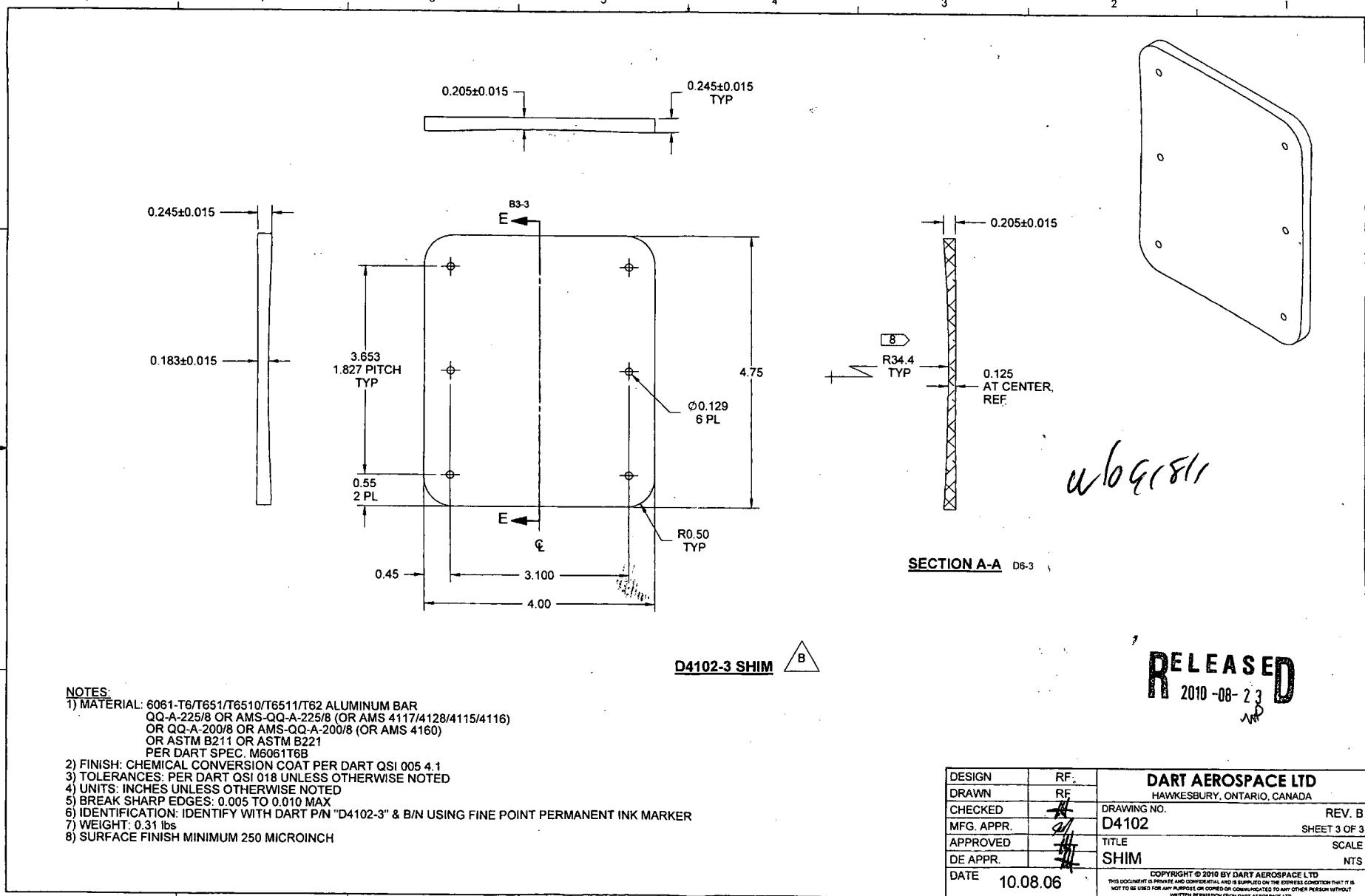
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